

**Work Order ID 55460**

January 19, 2010 9:49:02 AM

Page 1

Item ID: D3208-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Filler

Start Date: 1/19/10 Start Qty: 10.00

Required Date: 1/25/10 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-19

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3208

Rev A1

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blank: 2.750" x 4.300" Identify for D3208-7

m-h 10/01/19

10X

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Drill and Fillet D3208-7 corner as per Dwg D3208. Identify as D3208-7

m-h 10/01/19

10X

120

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr D3208-7. Polish any marks on part within 01. of Dwg D3208

m-h 10/01/19

10X

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8/10/12

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ M 10/01/27

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

10-01-21

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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January 19, 2010 9:49:02 AM



Page 3

Item ID: D3208-7

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Setup Start



Revision ID:

Stop



Item Name: Filler

Start Date: 1/19/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location 202

0.00



Packaging

Memo

0.00

Packaging

12-1-21

100 SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/22

MF 10-1-21

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

January 19, 2010 9:49:10 AM

Page 1

Work Order ID: 55460



Parent Item: D3208-7



Parent Item Name: Filler

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP: B04.05.25 Material changed for Step 4 KJ/JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	520.0628	0.9495			



2024-T3 .040 sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	520.0627789	
110305	192	
110337	6.4	
111786	32.0665789	
112291	50.1264	
112331	82.8641	
113162 ✓	156.6057	

0.9495

m-k 10/01/10

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

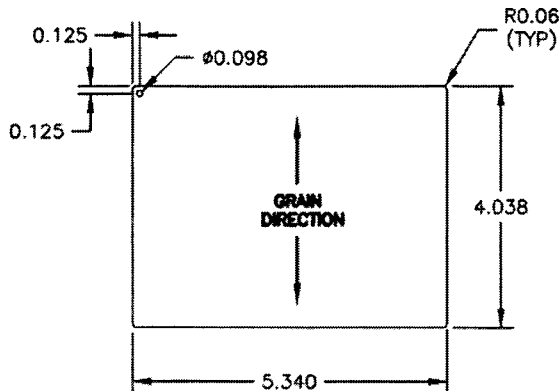
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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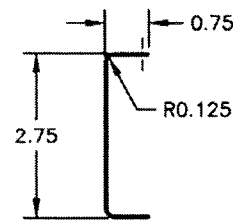


**DART**

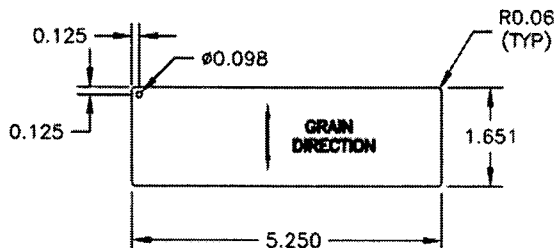
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	04.05.25	CHANGE DIM, NOTE 3) CHANGE	

**RELEASED**  
04 04 05

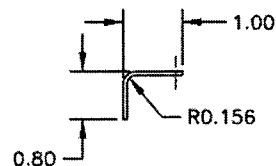
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

**NOTES:**

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

AI

- 3) MATERIAL: 6061-T6 (QQ-A-250/4) 0.063" THICK (M6061T6.063)

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WITHOUT NOTICE  
WORK ORDER  
NO. 55460

B/10-1-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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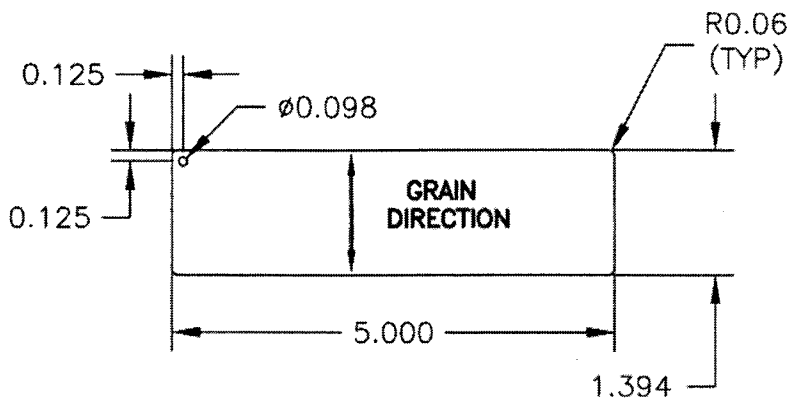
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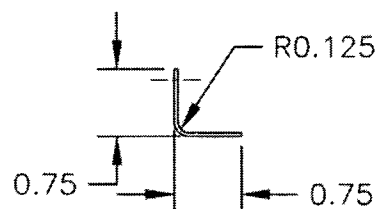


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CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

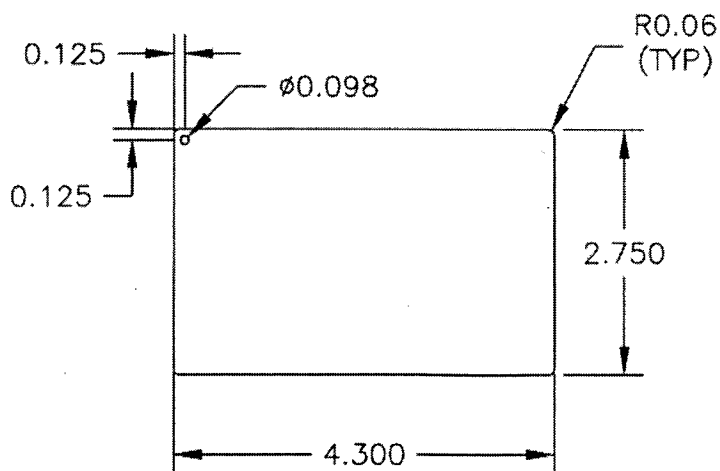
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04.04.05



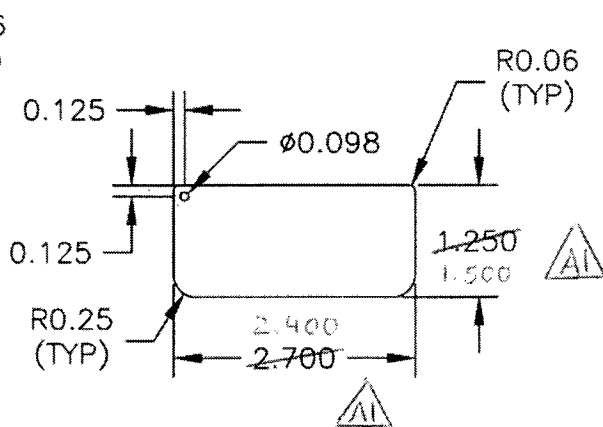
2 D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-5 MOUNT ANGLE  
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

W/O:		WORK ORDER CHANGES					
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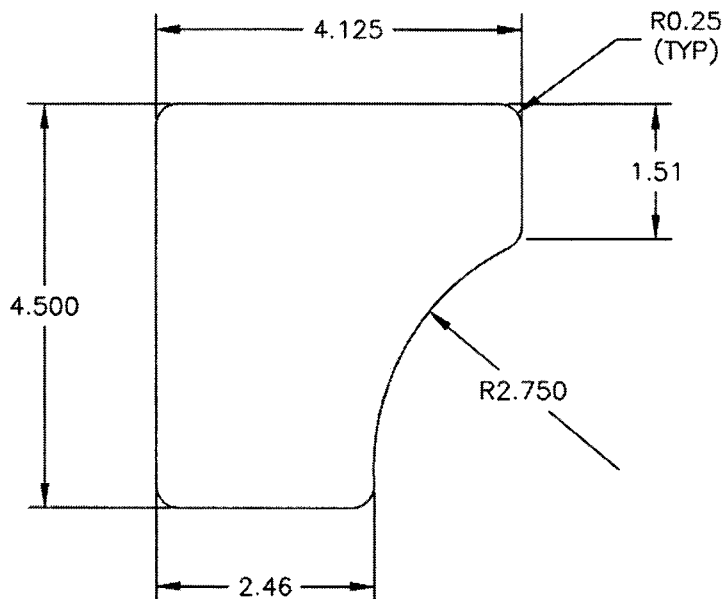
**NOTE:** Date & initial all entries



11/0 55460

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED  
04.04.05



**D3208-9 DOUBLER**

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